

10

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	18867
<b>Description:</b> Bracket Assembly		<b>Part Number:</b>	D3152-041
			D3152-042
<b>Drawing:</b> D3152 Rev.A		<b>Qty:</b>	12 Kits
D3152-1/-2 replaces Premier P/N: B30-23000-223/-224 D3152-3/-4 replaces Premier P/N: B30-23000-243/-244			Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller <b>Note: D3152-041/-042 Kits to be made in multiples of 12. Each Kit consists of Qty (1) of -041 and Qty (1) of -042.</b>	LD	03.02.26	12
2	PG	<b>Note: Each D3152 Kit ordered from Delastek consists of Qty (12) D3152-3 and Qty (12) D3152-4, therefore, for each multiple of 12 x D3152-041/-042 Kit, order Qty 1 x D3152 Seal Kit.</b> Issue P/O: <u>2005210</u> D3152-3/-4 Seal as per Dwg D3152 Supplier: Delastek Material: Black RTV <b>Material release note required</b>	LL	03.02.20	12
3	RG	Receive and inspect for transit damage. <b>Identify as D3152-3 and D3152-4 as per Dwg D3152.</b> <b>Ensure the material release note is attached</b>	LD	03.05.14	12
4	QC6	Inspect dimensions per Dwg D3152	LD	03.05.14	12
5	MV	<b>Note: Flat pattern makes either D3152-1 or D3152-2 therefore cut (2) blanks for each kit.</b> Cut blanks: (4.120" x 1.330") (+0.015/-0.00) grain along 4.120" Material: 2024-T3 (QQ-A-250/4) 0.063" thick. (M2024T3S.063) Batch: <u>M11225</u> <u>M11094</u>	ML	03/03/17	24
6	MV	Machine as per Folio FA311 and Dwg D3152 <b>Use stack of 4</b>	ML	03/03/18	12/24
7	QC2	Inspect parts as they come off the CNC machine	ML	03/03/18	12/24
8	MV	Deburr	ML	03/03/18	12/24
9	QC8	Second check	SL	03/03/19	12/24
10	GB	Form half of total stack as D3152-1 per Dwg D3152. <b>Identify as D3152-1</b>	ML	03/04/23	12/24
11	GB	Form other half of stack as D3152-2 per Dwg D3152. <b>Identify as D3152-2</b>	ML	03/04/23	12/24
12	QC5	Inspect work to Step 11	LD	03.04.23	24
13	FP	Chemical Conversion Coat per QSI 005 4.1	LD	03.04.23	24
14	FP	Powder Coat Grey Sandtex (4.3.5.6) per QSI 005 4.3	ML	03.05.08	24
15	QC3	Inspect Powder Coat	Z	03.05.08	24
16	GA	Bond D3152-3 Seal to D3152-1 Bracket using RTV 732 per Dwg D3152. RTV 732 Black Batch: <u>M13288</u> Identify as D3152-041 Expiry: <u>July 104</u>	SB	03.05.20	12

PP

RELEASED  
03.02.26